

Work Order ID 56068

February 9, 2010 1:28:06 PM



Page 1

Item ID:	D3942-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Angle					
Start Date:	2/09/10	Start Qty:	20.00		Cust Item ID:	
Required Date:	2/15/10	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>PI</i>	Date:	<i>10-2-09</i>	Tooling:	Date:		Run	Start	
	QC:		Date:		SPC (Y/N):	Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
	<i>A</i>								

100		0.00							<i>mat not pulled</i>
									<i>10-2-16</i>

Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3942-1								
<i>304.050</i>	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr if necessary								

= 7 Deburr m-h 10/02/17

(30X)

(30)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

10-2-16 P10 ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3942-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 2/09/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

810/02/17

counter
29

φ

P10

QC

Memo

0.00

Quality Control

130

Memo

0.00

810/02/22

29

Brake NC

1- Bend as per dwg D3942

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

810/02/23

counter
29

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3942-1 PAR #: _____ Fault Category: Small Flat/water Seal NCR: (Yes) No DQA: [Signature] Date: 10/03/02
 Resolution: Scrap Disposition: Scrap. QA: N/C Closed: [Signature] Date: 10/03/02

NCR: <u>56068</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/2/22	#110	Qty +1 ^{Angle} Part scrap - hole location are off. Re Part mixed During water water setting R.C. process	[Signature]	-Scrap + Destroy no replace Qty +1	SAD 10-02-22	S 10/2/23	[Signature]	J 10/02/22

NOTE: Date & initial all entries

Work Order ID 56068

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Page 3

Item ID: D3942-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 2/09/10

Start Qty: 20.00



Cust Item ID:

Required Date: 2/15/10

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Pickup 2/25 (29)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/02/26**ME 10-2-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

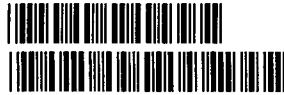
NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56068



Parent Item: D3942-1

Parent Item Name: Angle

Start Date: 2/09/10

Required Date: 2/15/10

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	225.4922	0.3158	<		
304/316 .050 Sheet												

18 10-2-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

225.4921632

108156

0.98526316

111743

23.7174

112885

72.7895

113062

128

112178

112178

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

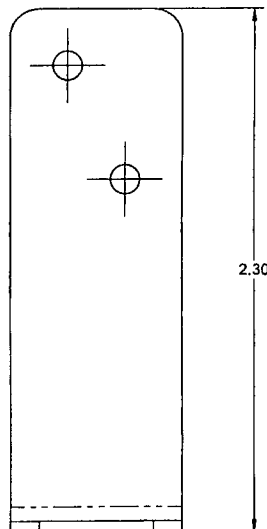
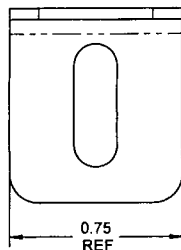
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

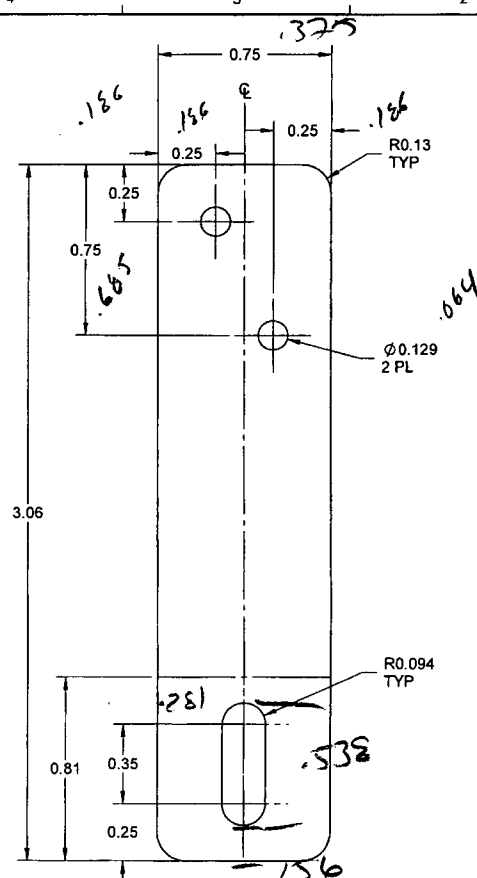
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 36068
10-2-09



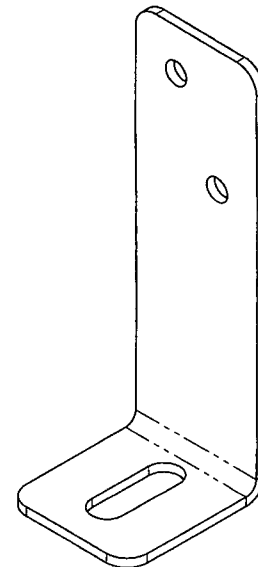
D3942-1F ANGLE
MADE FROM D3942-1F

0.050
REF

R0.06



D3942-1F FLAT PATTERN



RELEASED
09/06/09

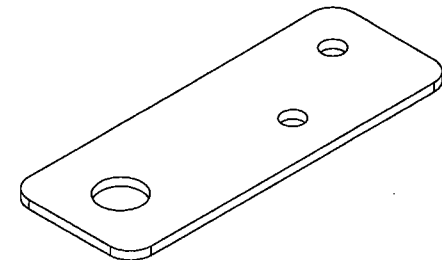
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

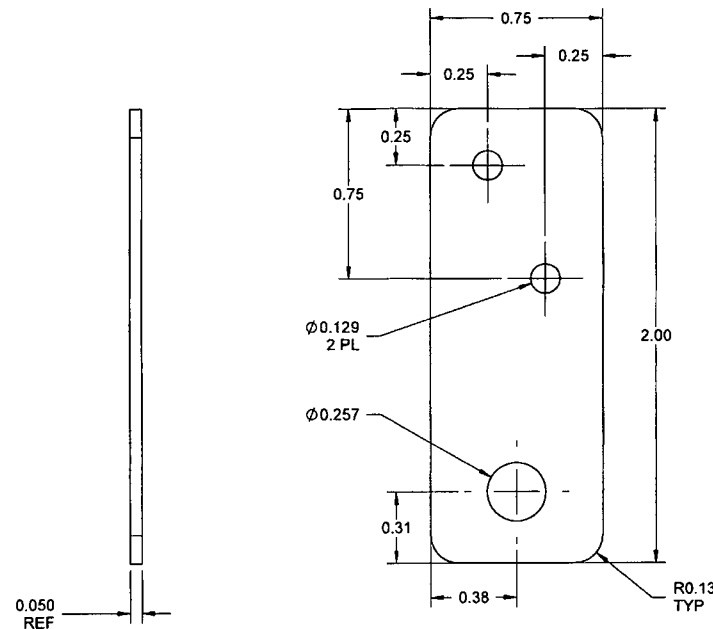
REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.05.06			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D3942	SHEET 1 OF 2
TITLE BRACKET	SCALE NTS

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w/o 56068



D3942-3 CLIP

RELEASED
09/05/06

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3942	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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